






Work Order ID 51154



August 12, 2009 9:58:25 AM



Page 1

Item ID: D3685-041 Accept  Setup Start 
 Revision ID: C Stop 
 Item Name: BIPOD MOUNT ASSEMBLY
 Start Date: 08/17/2009 Start Qty: 2.00  Cust Item ID:
 Required Date: 08/28/2009 Req'd Qty: 2.00  Customer:

Reference:


Approvals: Process Plan: mf Date: 09-08-12 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	Rev C

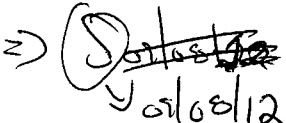
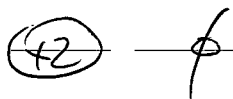
100	Pick Kit	0.00							
	Packaging	Memo	0.00						
	Packaging								

9/8/12 

110	Small Fab	0.00							
	Small Fab	Memo	0.00						
	Small Fab	1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685 □ 2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685 □ ***Ensure holes for AN3C Bolts are free o							

2 0
JB 09/02/12

120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	Memo	0.00						
	Quality Control								

②  9/8/12
④2 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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August 12, 2009 9:58:25 AM



Page 2

Item ID: D3685-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 139E

0.00

Memo

0.00

Packaging

9/5/122xSP

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

090813MF 09-08-13

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Picklist Print

August 12, 2009 9:58:25 AM

Page 1

13

Work Order ID: 51154



Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/28/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	613.0000	8.0000			
Bolts												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

613

106993

7

110155

2

110552

3

110584

68

111916

33

112314

500

22x MF 09-08-12

6x MF 09-08-12

D3684-047RevC

Manufactured

No



110

Each

6.0000

2.0000



FWD LEG ASS'Y

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

45600

1

Main Warehouse

ST139A

5

50729

5

MF
09-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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August 12, 2009 9:58:25 AM

Page 2 / 3

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Parent Item: D3685-041RevC

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/28/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3684-049RevC		Manufactured	No			110	Each	1.0000	2.0000			
AFT LEG ASS'Y												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

B 50742

MF 09-08-13

45601

1

D3687-3RevB

Manufactured

No

110

Each

15.0000

2.0000

MOUNT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

44684

2

45912

4

46761

9

AXUF 09-08-12

August 12, 2009 9:58:25 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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August 12, 2009 9:58:25 AM

Page 3 / 3

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Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/28/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB		Manufactured	No			110	Each	227.0000	16.0000			
SPACER												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 227

44827 28

45672 38

50325 161

Main Warehouse

ST127 161

NF 09-08-12

MS21043-3

Purchased

No

110

Each

5,558.000

8.0000



Nut

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 5478

111819 178

112243 300

112314 5000

8x NF 09-08-12

August 12, 2009 9:58:25 AM

Shop Packet Print

Page 3

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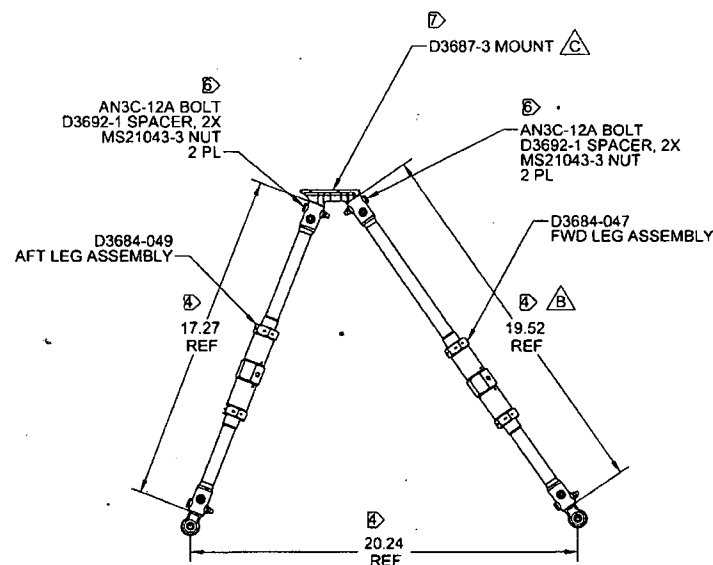
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN 84-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3685** REV. C
SHEET 1 OF 1
TITLE **BIPOD MOUNT ASSEMBLY** SCALE NTS

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RELEASED
09/01/15

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